

Work Order ID 110607

Friday, January 03, 2014 3:12:59 PM

\*110607\*

Page 1

Item ID: D3183-044

Revision ID:

Item Name: Bracket Assembly

Start Date: 1/3/2014 Start Qty: 8.00

Required Date: 1/31/2014 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: MWF Date: 14-01-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3183	Rev C1
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100

0.00

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: (1.500" x 2.250") 5.500" long

0.00

DA 14-01-05 (x8)

110

0.00

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3183-4 as per Folio FA322 and Dwg D3183Identify as D3183-42-Deburr3-Scribe batch number

0.00

14-01-08  
DA 14-01-09  
902-89

(x7)

(Pto) →

120

0.00

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

14-01-08

DQA:

Date: 14/01/30

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: 14-1-27

Work Order update only ☐

Work Order: 110607	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. D 3183-044		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. 14-3450		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
3451		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-01-09	110	x1	1" rougher pulled part out of fixture causing a gauge on one of the lobes for the spigot	DAS 12 9-89	SCRAP + Dusty	14-01-09	14/01/09	14/01/10
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 110607**

Friday, January 03, 2014 3:12:59 PM

**\*110607\***

Page 3

Item ID: D3183-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket Assembly  
Start Date: 1/3/2014 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 1/31/2014 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>57230B</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00				<u>7x</u>	<u>DAS</u> <u>28</u> <u>9-89</u>	<u>14-01-24</u>	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 1401-27

14-01-24

# Picklist Print

Friday, January 03, 2014 3:12:58 PM

Page 1

Work Order ID: 110607

Parent Item: D3183-044

Start Date: 1/3/2014

Required Date: 1/31/2014

Parent Item Name: Bracket Assembly

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

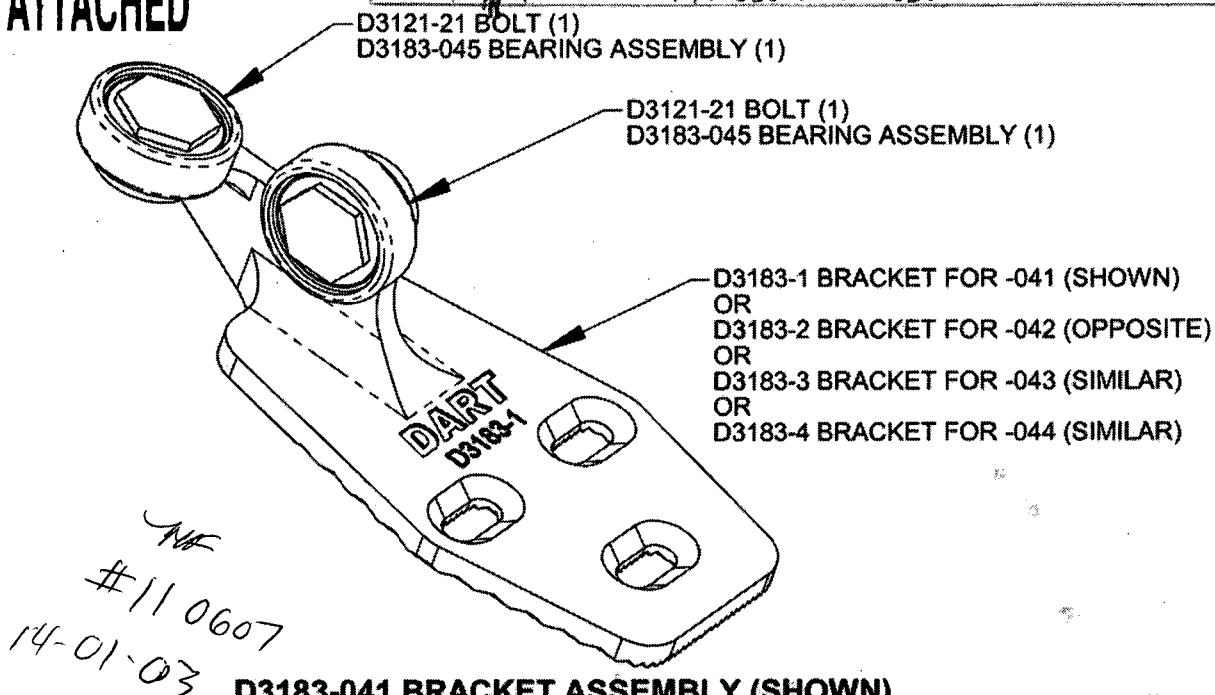
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21 Bolt		Manufactured	No			140	Each	102.0000	2	16		14/01/23	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		102							
				107164		22				11			
				107910		40							
				108636		40				3			
D3183-045 Bearing Assembly		Manufactured	No			100	Each	55.0000	2	16		14/01/23	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		5							
				88587		5							
				ST235B		50							
				108640		10				5			
				109094		40				9			
M174B1.500X02.250 17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	5.4000	0.4583	4		14-01-06	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT049		5.4							
				113568		1							
				115806		0.4							
				m126132		4				x4			

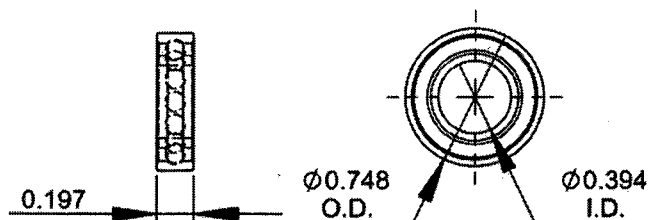
**DART**

DESIGN #	DRAWN BY IP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	# 04.11.09	0.830 WAS 0.850	

**RELEASED**  
04.03.01  
**DEO ATTACHED**



**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

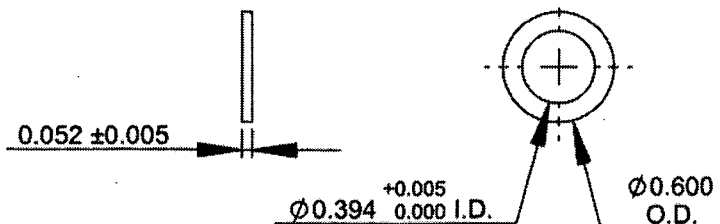


**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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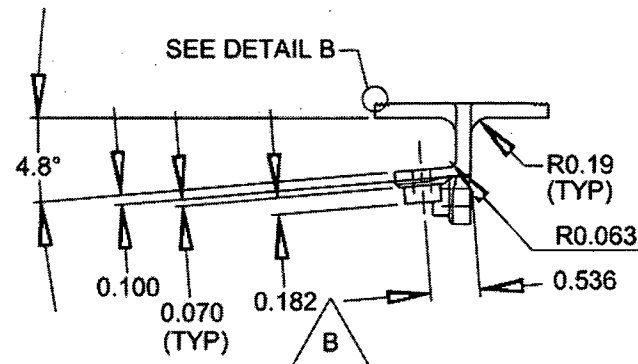
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**DART**

QA CONTROL

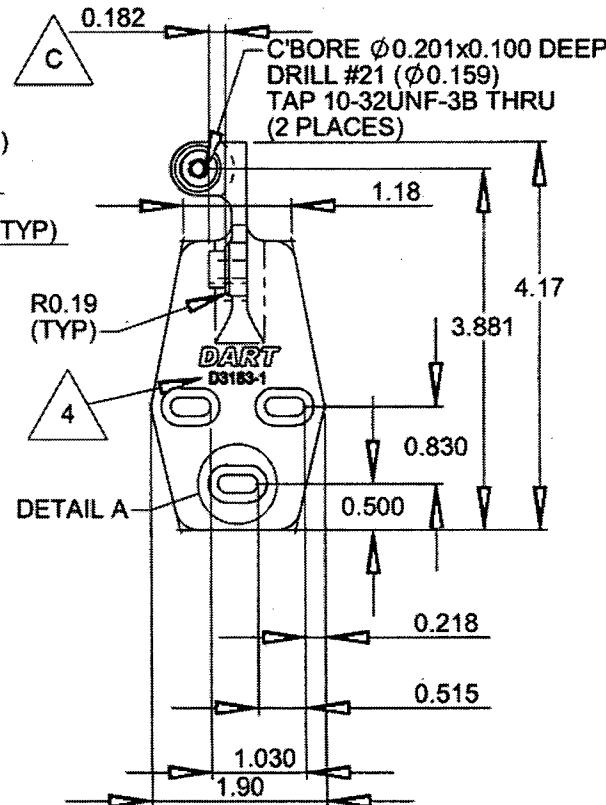
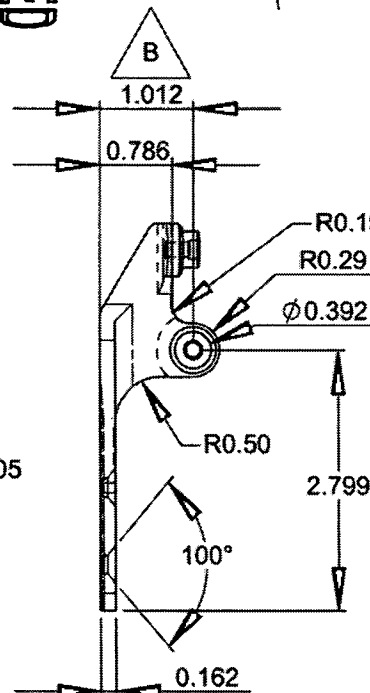
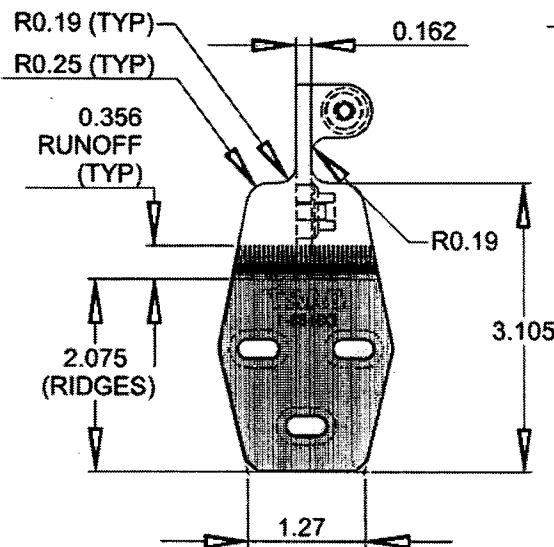
DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 2 OF 4
DATE	TITLE	SCALE	
04.02.17	BRACKET ASSEMBLY	1:2	

RELEASED



DEO ATTACHED

11067



**D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

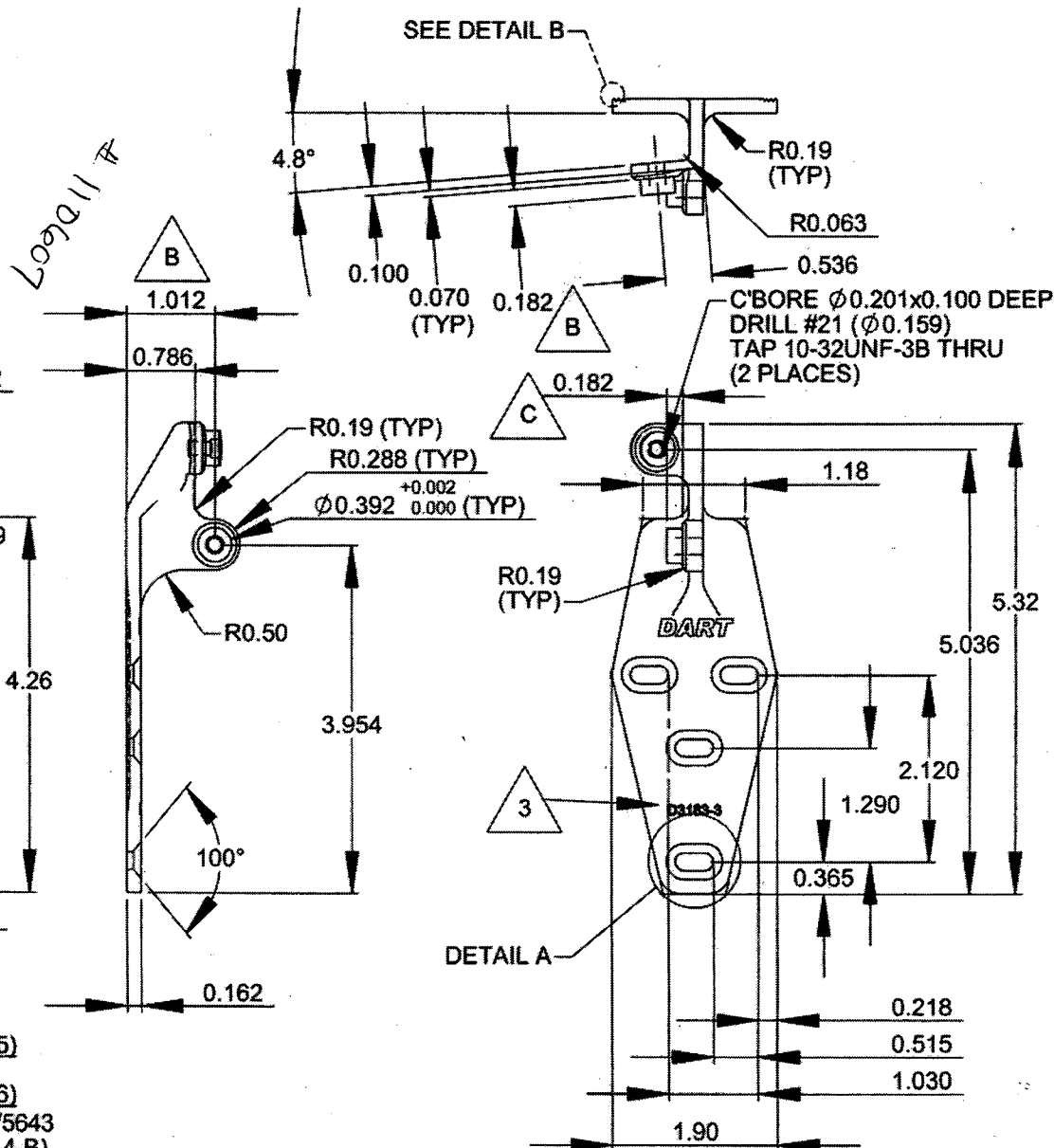
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# DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		DRAWING NO. D3183
		REV. C
		SHEET 3 OF 4
		SCALE 1:2



**D3183-3 BRACKET SHOWN**  
 (REPLACES BELL P/N 412-030-304-105)  
**D3183-4 BRACKET OPPOSITE**  
 (REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE STRENGTH = 150 ksi  
 MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**DEO ATTACHED**  
**RELEASED**

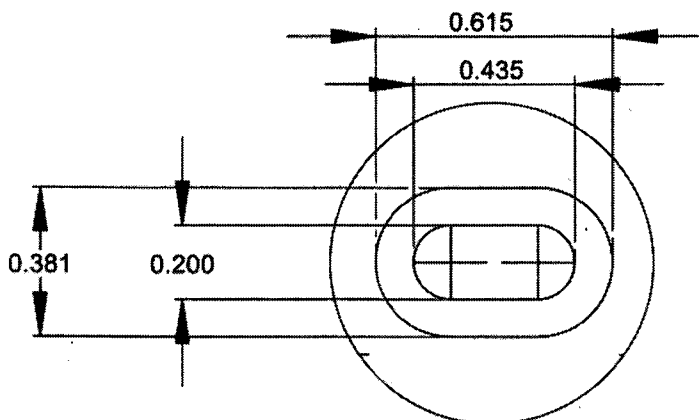
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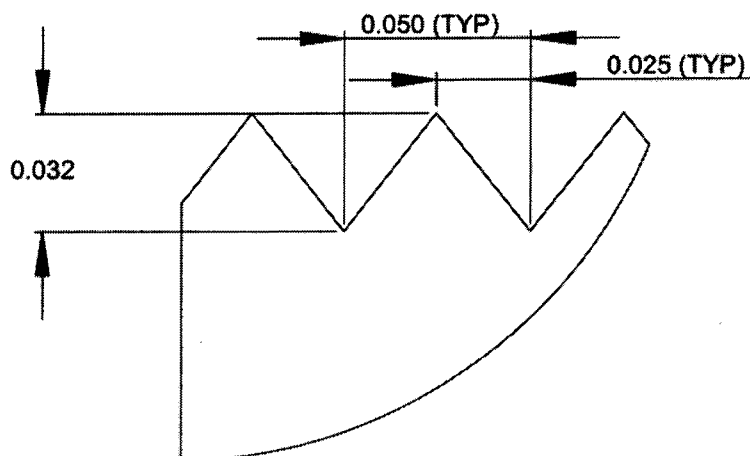
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



DETAIL A (2 : 1)

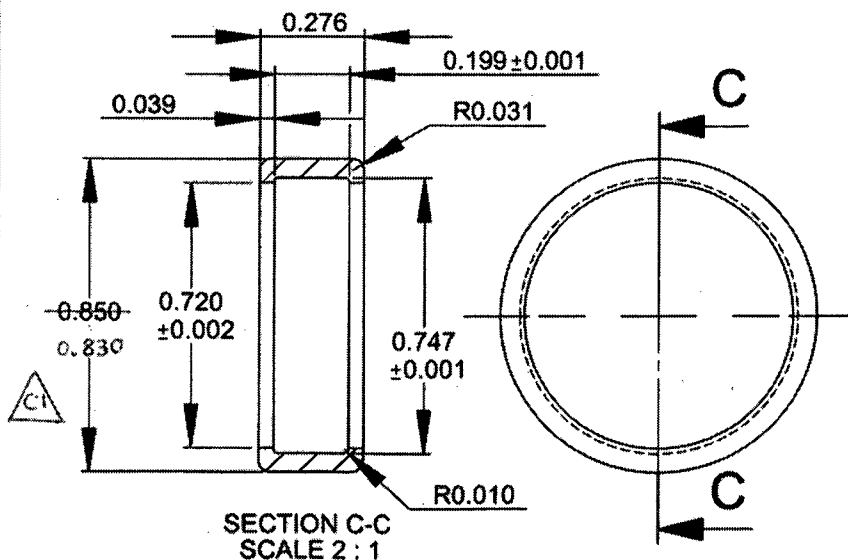
RELEASED  
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)

#110607



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 110607
<b>Description:</b> Bracket		<b>Part Number:</b> D3183-4
<b>Inspection Dwg:</b> D3183 <b>Rev:</b> C1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

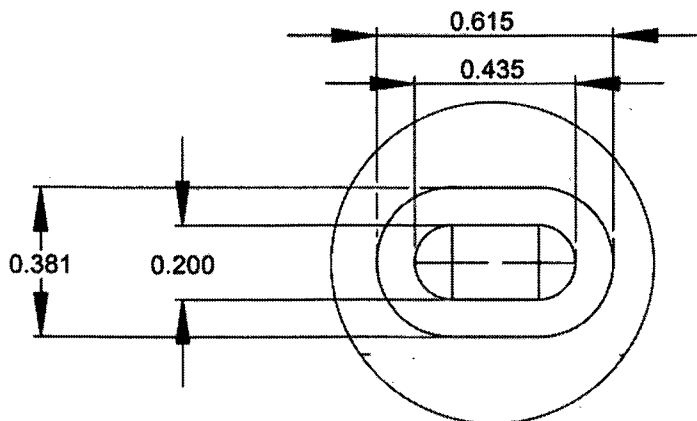
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	.188	✓		Rad gauge	
R0.063	+/-0.010	.063	✓		"	
0.182	+/-0.010	.187	✓		SLO8	Vern
0.070	+/-0.010	.067	✓		"	
0.100	+/-0.010	.106	✓		"	
Ø0.201 x 0.100	+/-0.010	.197 x .104	✓		"	
0.182	+/-0.010	.188	✓		"	
5.32	+/-0.030	5.321	✓		"	
5.036	+/-0.010	5.034	✓		Height Gauge	
2.120	+/-0.010	2.120	✓		"	
1.290	+/-0.010	1.290	✓		"	
0.365	+/-0.010	.363	✓		SLO8	Vern
0.218	+/-0.010	.213	✓		"	
1.030	+/-0.010	1.029	✓		"	
1.90	+/-0.030	1.888	✓		"	
1.012	+/-0.010	1.007	✓		"	
Ø0.201 x 0.100	+/-0.010	.197 x .104	✓		"	
0.786	+/-0.010	.785	✓		"	
Ø0.392	+0.002/-0.000	.3934	✓		SLO2 Mic	
R0.19	+/-0.030	.188	✓		Rad gauge	
3.954	+/-0.010	3.9515	✓		Height gauge	
0.162	+/-0.010	.163	✓		SLO8 Vern	
R0.19	+/-0.030	.188	✓		Rad gauge	
R0.25	+/-0.030	.250	✓		"	
4.26	+/-0.030	4.262	✓		Height gauge	
2.800	+/-0.030	2.790	✓		SLO8 Vern	
Calculated dimension					SLO8 Vern	
0.162	+/-0.010	.162	✓		"	
0.615	+/-0.010	.615	✓		"	
0.435	+/-0.010	.428	✓		"	
0.200	+/-0.010	.204	✓		"	
0.381	+/-0.010	.380	✓		"	
0.032	+/-0.010	.028	✓		Depth Gauge	

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i> 08	<b>Preliminary Approval:</b> N/A
<b>Date:</b> 14-01-07	<b>Date:</b> 14/01/22	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ <i>[Signature]</i>	<i>[Signature]</i>



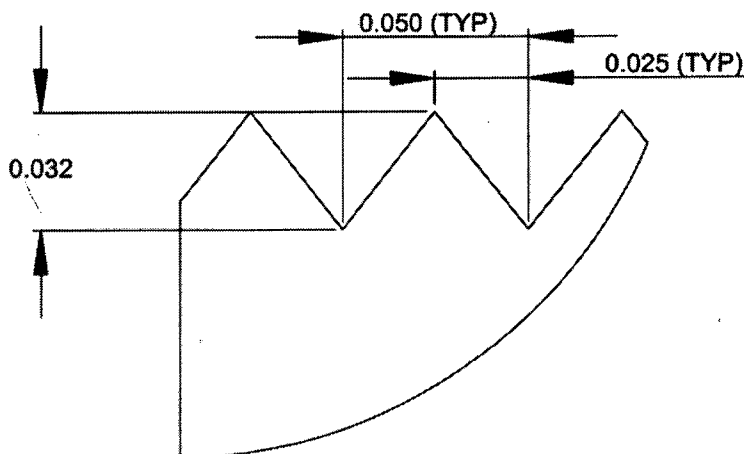
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



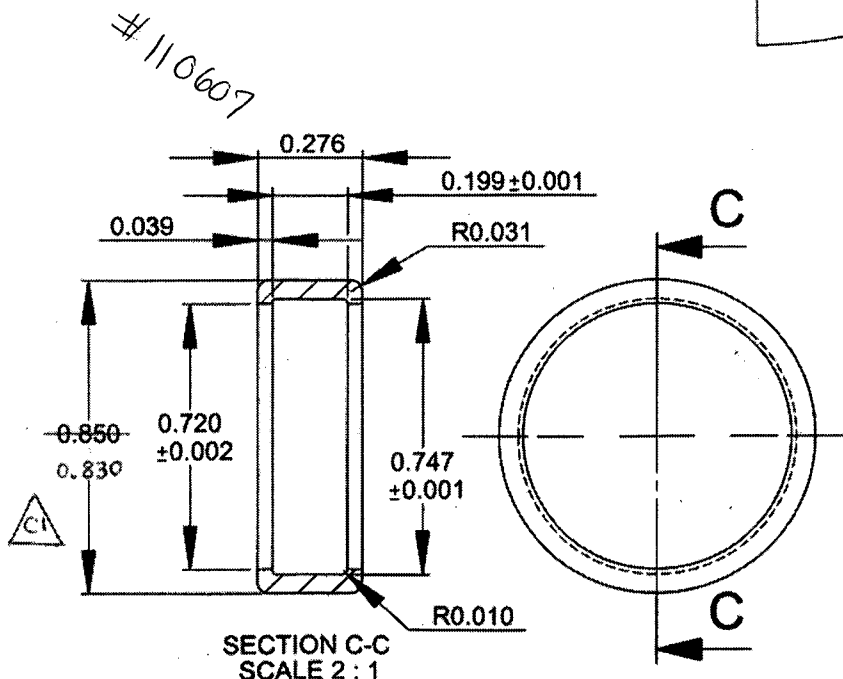
DETAIL A (2 : 1)

RELEASED  
04.03.01 *[Signature]*

DEO ATTACHED



DETAIL B (20 : 1)



SECTION C-C  
SCALE 2 : 1

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

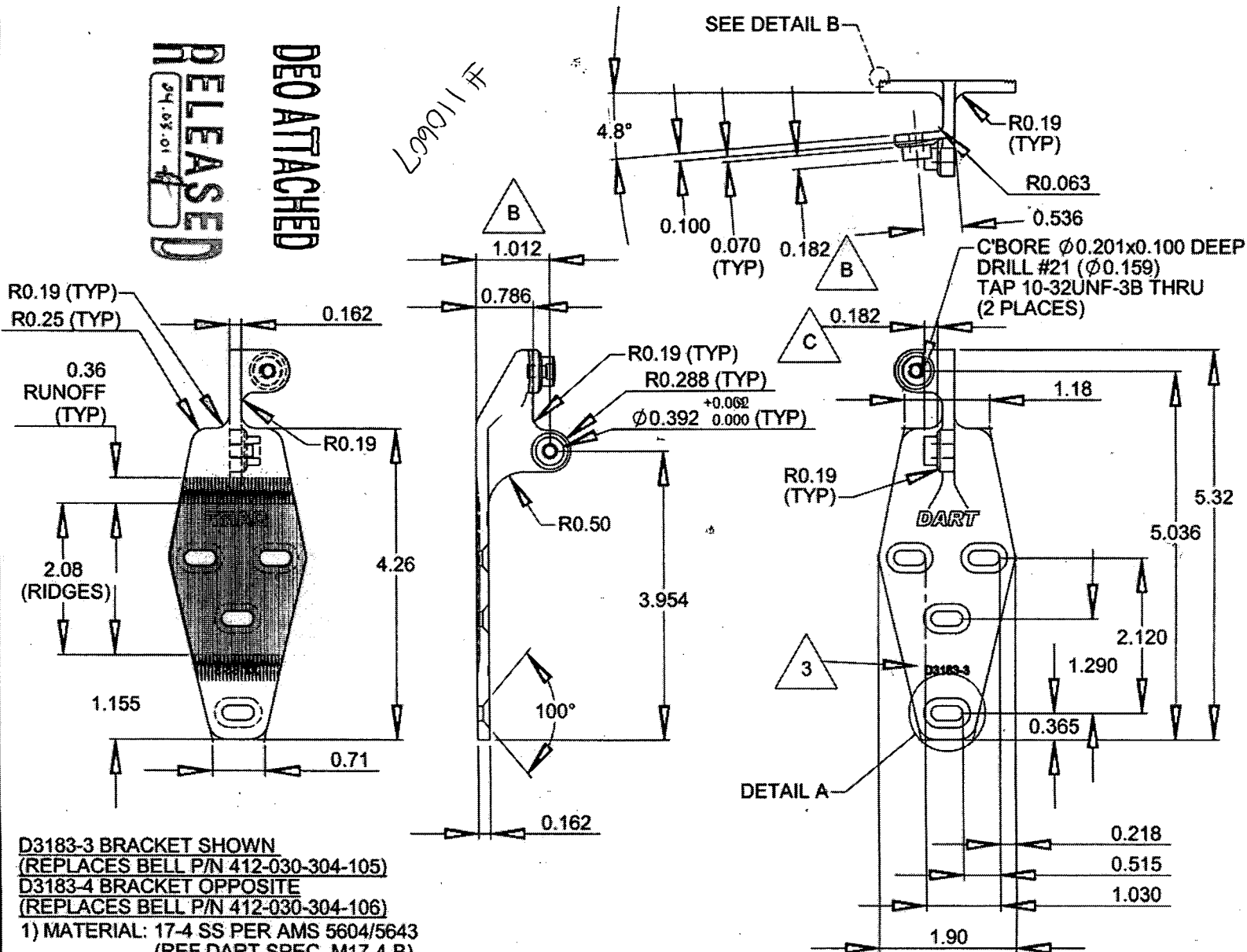
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DEATTACHED  
RELEASED  
04.03.01



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: <u>110603</u> Part No. <u>D3183-044</u> NCR No. _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	14/1/22	110	4	0.162 thickness is 0.174 on one edge (top). R.C. operator.	<b>DAS</b> <b>12</b> <b>9-89</b>  14/1/22	Acceptable. <del>Teeth</del> Teeth/grooves still have sufficient coverage, no effect on fit.	<b>DAS</b> <b>12</b> <b>9-89</b>  14/1/22	<b>DAS</b> <b>08</b> <b>9-89</b>  J.A 14/01/22	<b>DAS</b> <b>16</b> <b>9-89</b>  14/01/27
Equip/Tooling <input type="checkbox"/>									
Operator <input checked="" type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other